

Date: Monday, 25/05/2009 1:30:37 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : A119 STEP WELDMENT RH
 Job Number : 48175A
 Estimate Number : 10130
 P.O. Number :
 This Issue : 25/05/2009 S.O. No. :
 Prsht Rev. : NC Part Number : D3043042
 First Issue : // Type : LARGE FAB ASSY Drawing Number : D3043 REV A
 Previous Run : 46572A Project Number : N/A
 Material :
 Due Date : 10/06/2009 Qty: 6 Um: Each
 Written By :
 Checked & Approved By : JLD 09-05-25
 Comment : Est Rev : A New Issue JLM 05-11-01

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2622120C Step Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)
 Pick: D2622-120C extrusion
 Batch: 46910

SAD 09-06-01

2.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2622-120 extrusion to 120.00" long as per Dwg D3043 using cutting table setup DT8185-G

2-Deburr and bevel ends for welding

SAD 09-06-01 (6)

3.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SAD 09-06-01 (76)

4.0 D2734 Step End Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)
 Pick:
 Qty Part Number Description Batch
 2 D2734 End Cap 343535

SAD 09-06-03 6

5.0 D30401 Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)
 Pick:
 Qty Part Number Description Batch
 2 D3040-1 Mounting Lug 346849-4 342944-8

SAD 09-06-03 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 25/05/2009 1:30:38 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: A119 STEP WELDMENT RH

Job Number: 48175A

Part Number: D3043042

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D30403

Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3040-3 Mounting Lug 342945

Handwritten: 09.06.04 6

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld 1 End Cap & Mounting Lugs as per QSI 004 & Dwg D3043 Using DT8808

AR AL ROD Batch: M110130
M110972

2-Grind Fwd End Cap weld flush

Handwritten: 09.06.04 6
09.06.04 6

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

Handwritten: 09.06.04 (6)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Handwritten: 09/06/04 (6) RH

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Handwritten: (P12) 7

1-Chemical Conversion Coat as per QSI 005 4.1

Handwritten: 09.06.05 6

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-1-Weld 1 End Cap as per QSI 004 & Dwg D3043

AR AL ROD Batch: M110130

2-Inspect for foreign object as per QSI 024

Handwritten: 09.06.08 6
09.06.08 6

W/O: 48157A		EST: 10130		WORK ORDER CHANGES				
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
9/6/08	10-1	Perm. change inspect w/line / chemical cont ACS. *SAD 09/06/08	HJ	09/06/08 already done		/ 09/06/08	S 09/06/08	

Part No: D3043-042 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 25/05/2009 1:30:38 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: A119 STEP WELDMENT RH

Job Number: 48175A

Part Number: D3043042

Job Number:



Seq. #:

Machine Or Operation:

Description :

3-Grind Fwd End Cap weld flush

12.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 09.06.08 (6)

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/06/08 (6 RH)

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Touch up Chemical Conversion Coat as per QSI 005 4.1

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Inspect alodine

09-06-11

(X 6 RM)

16.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: 9:00 AM

OVEN TEMPERATURE: 320°F

FINISH TIME: 9:30 AM

09-06-11 (X 6 RM)

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Wing Walk as per Dwg D3043 and QSI 005 4.4

FL 09/06/11

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PC 9/6/11 (6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 25/05/2009 1:30:38 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: A119 STEP WELDMENT RH

Job Number: 48175A

Part Number: D3043042

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *PPD 98/75*

Rec'd 17

(6)

20.0

QC21

FINAL INSPECTION/W/O RELEASE



09/06/18

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-06-17

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3043	REV. A SHEET 1 OF 2
DATE 01.06.28		TITLE A119 STEP WELDMENT	SCALE NTS
A	01.06.28	NEW ISSUE	

PARTS LIST:

Qty -041	Qty -043	Part Number	Description
X		D3043-041	STEP WELDMENT, LH
	X	D3043-042	STEP WELDMENT, RH
1	1	D2622-120	STEP EXTRUSION
2	2	D3040-1	MOUNTING LUG
2	2	D3040-3	MOUNTING LUG
2	2	D2734	ENDPLATE

NOTES:

- 1) MANUFACTURE FROM D2622-120 EXTRUSION
- 2) WELD PER DART QSI 004. ALL WELDS SHOULD BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004
- 3) FINISH: ACID ETCH & ALODINE ASSEMBLY PER DART QSI 005 4.1
POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT TOP SURFACE OF STEP TO BOTTOM OF TOP
RADIUS PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
01.07.05 *[Signature]*

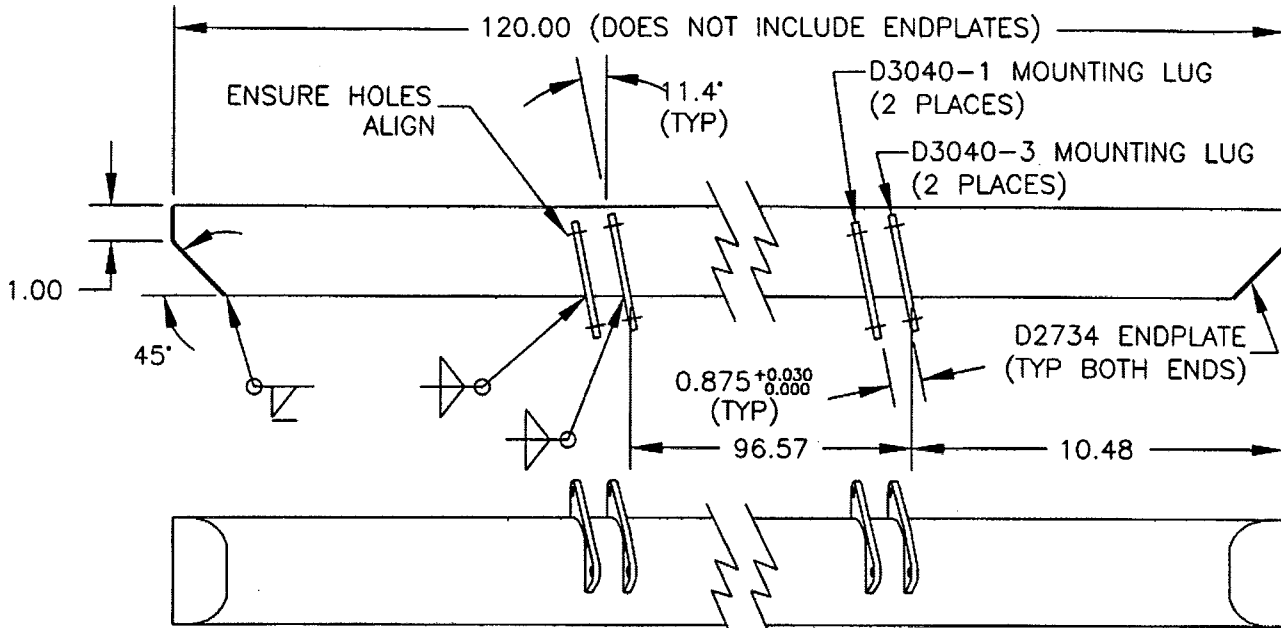
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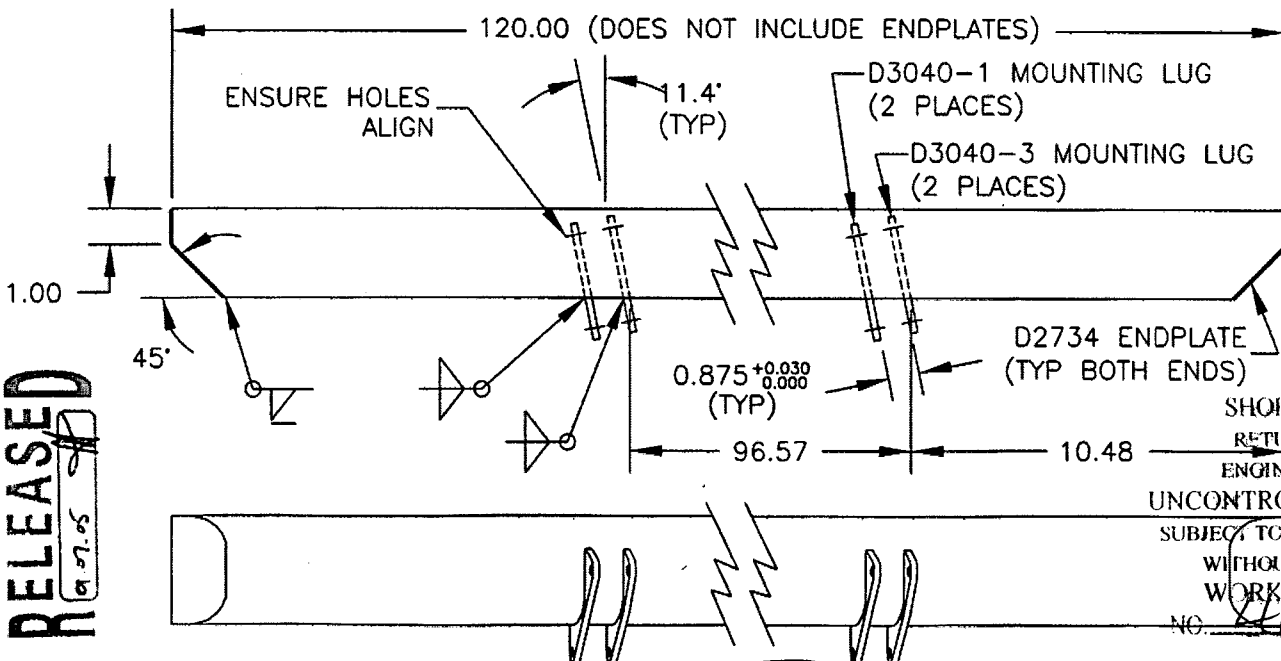
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CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3043	REV. A SHEET 2 OF 2
DATE 01.06.28		TITLE A119 STEP WELDMENT	SCALE 1:5
A	01.06.28	NEW ISSUE	



VIEW A-A: D3043-041 LH STEP WELDMENT



VIEW A-A: D3043-042 (RH) STEP WELDMENT

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